

AMENDMENT TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims

Claims 1. – 97. (Canceled).

98. (Currently amended) Machine for producing a multilayer fibrous web, in particular a paper or board web, comprising:

at least two gap formers structured to form at least two layers having a higher content of fines on one side; in which the layers formed by a respective former are couched with each other, a couching zone in which the at least two layers to be are couched with each other;

the at least two gap formers are arranged so that the one side of each of the at least two layers having the higher content of fines are and each having a higher content of fines on one side being fed to the relevant couching zone in such a way that they the one sides of the at least two layers having the higher content of fines come into contact with each other with their sides having a higher content of fines, at least two of these layers being produced by a gap former in each case, which comprises;

the at least two gap formers each comprises a forming roll, a forming shoe, and two circulating endless dewatering belts, which the two circulating belts being arranged to run together, in each case forming a stock inlet arranged to be charged with a fibrous suspension from a headbox as they produce and an adjoining twin-wire zone, and, in the region of this

~~charged stock inlet charged with fibrous suspension by a headbox, are being led over [[a]] the forming roll, and the sheet formation of whereby the sheet formation of the at least two layers in each case taking place the one side with [[a]] the higher content of fines is located on the forming roll side, wherein and, starting immediately from the forming roll, the respective twin-wire zone run downward, and in that, in the section of the respective twin-wire zone that runs downwards, in each case a in such a manner that the forming shoe resting rests on the respective upper dewatering belt is provided.~~

99. (*Currently amended*) Machine according to Claim 98, wherein ~~the~~ belt running directions of the at least two gap formers are opposite to each other.

100. (*Currently amended*) Machine according to Claim 99, wherein the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and wherein the layer formed in ~~the~~ a first of the two gap formers, together with at least one of the two dewatering belts arranged as an endless belt, is led around a deflection element, ~~preferably a deflection roll, and, after that, by means of an endless belt, is~~ and then is fed, via the endless belt, to the relevant couching zone in a direction generally opposite to ~~the~~ a jet direction of the first headbox, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

101. (*Currently amended*) Machine according to Claim 100, wherein the layer formed in the first gap former, together with the outer dewatering belt not coming into contact with the

forming ~~element~~ roll, is led around the deflection element and is fed to the couching zone by means of this outer dewatering belt.

102. (*Currently amended*) Machine according to Claim 101, wherein both dewatering belts in the first gap former are led around the deflection element and, after ~~this~~ the deflection element, the inner dewatering belt is separated from the outer dewatering belt, which carries ~~carrying~~ the layer with it.

103. (*Currently amended*) Machine according to Claim 101, wherein, after the deflection element, the outer dewatering belt of the first gap former is ~~preferably~~ led generally in the horizontal direction, at least as far as ~~the~~ a region of the couching zone.

104. (*Currently amended*) Machine according to Claim 100, wherein a further layer is formed by a Fourdrinier former and the sheet formation of ~~this~~ the further layer is carried out ~~with~~ to attain a higher contents of fines on ~~the~~ an outer side facing away from ~~the~~ a Fourdrinier wire, in that the layer formed in the first gap former and led over the deflection element is couched together with the layer formed by the Fourdrinier former, and in that these two layers are fed to the couching zone by ~~means of~~ the Fourdrinier wire, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

105. (*Currently amended*) Machine according to Claim 104, wherein the outer

dewatering belt of the first gap former is separated from the inner dewatering belt and the ~~relevant~~ layer before the deflection element in the belt running direction, and the layer is only led around the deflection element together with the inner dewatering belt.

106. (*Currently amended*) Machine according to Claim 104, wherein the layer formed in the Fourdrinier former and the layer formed in the first gap former are couched with each other in ~~the~~ a region of at least one of the deflection element ~~and/or~~ and a couch roll.

107. (*Currently amended*) Machine according to claim 98, wherein, in a second of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after ~~the~~ a separation of the two dewatering belts of the second gap former, the layer formed by the second gap former, together with the outer dewatering belt, is fed to the couching zone, in which the two layers formed in the two gap formers are couched with their sides of higher fines content together.

108. (*Currently amended*) Machine according to Claim 98, wherein a ~~first of the layers~~ further layer to be couched ~~with their sides of higher fines content together~~ is formed by a Fourdrinier former and the sheet formation of ~~this first~~ the further layer is carried out with a higher content of fines on the outer side, facing away from ~~the~~ a Fourdrinier wire, ~~and in that further layers are each formed by a gap former and the sheet formation of these layers is carried out with a higher content of fines on the forming element side, and~~

wherein the outer side of the further layer having the higher content of fines is couched with the layers from the two gap formers.

109. *(Currently amended)* Machine according to Claim 108, wherein ~~the~~ a jet direction of the headbox ~~assigned to~~ of at least one of the two gap former formers corresponds generally to ~~the~~ a running direction of the ~~first~~ further layer formed by the Fourdrinier former.

110. *(Currently amended)* Machine according to Claim 108, wherein, in a first of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after ~~the~~ a separation of the two dewatering belts of the first gap former, the layer formed by the first gap former, together with the outer dewatering belt, is fed to the couching zone, in which the ~~said~~ outer dewatering belt is led together with the Fourdrinier wire in order to couch the two layers.

111. *(Previously presented)* Machine according to Claim 108, wherein the Fourdrinier wire is preferably led generally in the horizontal direction, at least in the region of the couching zone.

112. *(Currently amended)* Machine according to claim 98, wherein, in order to form an at least three-layer ~~or four-layer~~ fibrous web, at least one additional gap former is provided

and ~~the~~ a sheet formation of the additional layer is ~~carried out~~ attained with a higher content of fines on ~~the~~ a forming element side, and in that the higher content of fines of the additional layer is couched in an additional couching zone with the ~~layer~~ layers formed by the ~~preceding two~~ gap former formers, at least one of the two layers being couched with the other layer with a side of higher fines content.

113. (*Currently amended*) Machine according to Claim 112, wherein ~~the~~ a jet direction of the headbox assigned to the additional gap former corresponds to ~~the~~ a running direction of the fibrous web to be formed.

114. (*Currently amended*) Machine according to claim 98, wherein the headbox associated with each of the two gap formers comprises at least one multilayer headbox, ~~and/or~~ at least one single-layer headbox, and ~~and/or~~ a combination of different headboxes ~~is provided~~.

115. (*Currently amended*) Machine according to claim 98, wherein the headbox associated with each of the two gap formers comprises at least one single-layer headbox ~~is provided~~.

116. (*Previously presented*) Machine according to claim 98, wherein equal pressure dewatering elements are provided for belt dewatering.

117. (*Currently amended*) Process for producing a multilayer fibrous web, ~~in particular a paper or board web, comprising:~~

forming at least two layers with at least two gap formers, the in which the layers formed by a respective former are couched with each other, at least two layers to be being formed to have one side a higher fines content;

couching together couched with each other and each having a the at least two layers in a manner that the one sides of the at least two layers having the higher content of fines on one side being fed to the relevant couching zone in such a way that they come into contact with each other; with their sides having a higher content of fines, at least two of these layers being produced by a gap former in each case, which comprises

wherein the at least two gap formers each comprises a forming roll, a forming shoe, and two circulating endless dewatering belts, which the two circulating belts being arranged to run together, in each case forming a stock inlet arranged to be charged with a fibrous suspension from a headbox as they produce and an adjoining twin-wire zone; and, in the region of this

the method further comprising:

charging the stock inlet charged with the fibrous suspension by a headbox, are led and leading the charged stock inlet over [[a]] the forming roll, and the sheet formation of whereby the sheet formation of the at least two layers in each case taking place the one side with [[a]] the higher content of fines is located on the forming roll side, wherein, and

starting immediately from the forming roll, leading the at least two layers are led downwards in the respective twin-wire zone downward and in such a manner to lead the forming shoe rests on [[,]] and in that, in the section of the respective twin-wire zone that runs

~~downwards, the respective upper dewatering belt is led past resting on a forming shoe.~~

118. (*Currently amended*) Process according to Claim 117, wherein the two gap formers are arranged with opposite belt running directions ~~are used~~.

119. (*Currently amended*) Process according to Claim 118, wherein the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and wherein the layer formed in ~~the~~ a first of the two gap formers, together with at least one of the two dewatering belts arranged as an endless belt, is led around a deflection element, ~~preferably a deflection roll, and, after that, by means of an endless belt, is~~ and then is fed, via the endless belt, to the relevant couching zone in a direction generally opposite to ~~the~~ a jet direction of the first headbox, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

120. (*Currently amended*) Process according to Claim 119, wherein the layer formed in the first gap former, together with the outer dewatering belt not coming into contact with the forming ~~element~~ roll, is led around the deflection element and is fed to the couching zone by means of this outer dewatering belt.

121. (*Currently amended*) Process according to Claim 120, wherein both dewatering belts in the first gap former are led around the deflection element and, after ~~this~~ the deflection

element, the inner dewatering belt is separated from the outer dewatering belt, which carries
~~carrying~~ the layer with it.

122. (*Currently amended*) Process according to Claim 121, wherein a further layer is formed by a Fourdrinier former and the sheet formation of ~~this~~ the further layer is carried out ~~with to attain~~ a higher contents of fines on ~~the~~ an outer side facing away from ~~the~~ a Fourdrinier wire, in that the layer formed in the first gap former and led over the deflection element is couched together with the layer formed by the Fourdrinier former, and in that these two layers are fed to the couching zone by ~~means of~~ the Fourdrinier wire, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

123. (*Currently amended*) Process according to Claim 122, wherein the outer dewatering belt of the first gap former is separated from the inner dewatering belt and the ~~relevant~~ layer before the deflection element in the belt running direction, and the layer is only led around the deflection element together with the inner dewatering belt.

124. (*Currently amended*) Process according to Claim 122, wherein the layer formed in the Fourdrinier former and the layer formed in the first gap former are couched together in ~~the~~ a region of at least one of the deflection element ~~and/or~~ and a couch roll.

125. (*Currently amended*) Process according to one of Claims 117, wherein, in a

second of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after ~~the~~ a separation of the two dewatering belts of the second gap former, the layer formed by the second gap former, together with the outer dewatering belt, is fed to the couching zone, in which the two layers formed in the two gap formers are couched with their sides of higher fines content together.

126. *(Currently amended)* Process according to Claim 117, wherein a ~~first of the layers~~ further layer to be couched ~~with their sides of higher fines content together~~ is formed by a Fourdrinier former and the sheet formation of ~~this first~~ the further layer is carried out with a higher content of fines on the outer side, facing away from ~~the a~~ Fourdrinier wire, ~~and in that further layers are each formed by a gap former and the sheet formation of these layers is carried out with a higher content of fines on the forming element side, and~~

wherein the outer side of the further layer having the higher content of fines is couched with the layers from the two gap formers.

127. *(Currently amended)* Process Machine according to Claim 126, wherein ~~the a~~ jet direction of the headbox ~~assigned to~~ of at least one of the two gap former formers corresponds generally to ~~the a~~ running direction of the ~~first~~ further layer formed by the Fourdrinier former.

128. *(Currently amended)* Process according to Claim 126, wherein, in a first of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner

and an outer dewatering belt relative to the forming roll, and

wherein, after ~~the~~ a separation of the two dewatering belts of the first gap former, the layer formed by the first gap former, together with the outer dewatering belt, is fed to the couching zone, in which the ~~said~~ outer dewatering belt is led together with the Fourdrinier wire in order to couch the two layers.

129. (*Currently amended*) Process according to Claims 117, wherein, in order to form an at least three-layer ~~or four-layer~~ fibrous web, at least one additional gap former is provided and ~~the~~ a sheet formation of the additional layer is ~~carried out~~ attained with a higher content of fines on ~~the~~ a forming element side, and in that the higher content of fines of the additional layer is couched in an additional couching zone with the ~~layer~~ layers formed by the ~~preceding two~~ gap ~~former~~ formers, at least one of the two layers being couched with the other layer with a side of higher fines content.

130. (*Currently amended*) Process according to Claim 129, wherein ~~the~~ a jet direction of the headbox assigned to the additional gap former is chosen so as to correspond to ~~the~~ a running direction of the fibrous web to be formed.

131. (*Currently amended*) Process according to Claims 117, wherein the headbox associated with each of the two gap formers comprises at least one single-layer headbox ~~is~~ provided.